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U.S. DEPARTMENT OF COMMERCE PATENT AND TRADEMARK OFFICE

ATTORNEY'S DOCKET NUMBER

**TRANSMITTAL LETTER TO THE UNITED STATES  
DESIGNATED/ELECTED OFFICE (DO/EO/US)  
CONCERNING A FILING UNDER 35 U.S.C. 371**

**TRM TR990031**

U.S. APPLICATION NO. (IF KNOWN, SEE 37 CFR

**10/089558**

INTERNATIONAL APPLICATION NO.  
**PCT/US00/26901**

INTERNATIONAL FILING DATE  
**29 September 2000**

PRIORITY DATE CLAIMED  
**30 September 1999**

TITLE OF INVENTION

**Method and Apparatus for Molding Plastic Materials with a Metallic Appearance**

APPLICANT(S) FOR DO/EO/US

**Paul Sylvester LAFATA and  
Jack William HISE**

Applicant herewith submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. 371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
3. ☒ This is an express request to begin national examination procedures (35 U.S.C. 371(f)). The submission must include items (5), (6), (9) and (24) indicated below.
4. ☒ The US has been elected by the expiration of 19 months from the priority date (Article 31).
5. ☒ A copy of the International Application as filed (35 U.S.C. 371 (c) (2))
  - a. ☐ is attached hereto (required only if not communicated by the International Bureau).
  - b. ☒ has been communicated by the International Bureau.
  - c. ☒ is not required, as the application was filed in the United States Receiving Office (RO/US).
6. ☐ An English language translation of the International Application as filed (35 U.S.C. 371(c)(2)).
  - a. ☐ is attached hereto.
  - b. ☐ has been previously submitted under 35 U.S.C. 154(d)(4).
7. ☐ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371 (c)(3))
  - a. ☐ are attached hereto (required only if not communicated by the International Bureau).
  - b. ☐ have been communicated by the International Bureau.
  - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
  - d. ☐ have not been made and will not be made.
8. ☐ An English language translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).
9. ☐ An oath or declaration of the inventor(s) (35 U.S.C. 371 (c)(4)).
10. ☐ An English language translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371 (c)(5)).
11. ☒ A copy of the International Preliminary Examination Report (PCT/IPEA/409).
12. ☐ A copy of the International Search Report (PCT/ISA/210).

**Items 13 to 20 below concern document(s) or information included:**

13. ☐ An Information Disclosure Statement under 37 CFR 1.97 and 1.98.
14. ☐ An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.
15. ☐ A **FIRST** preliminary amendment.
16. ☐ A **SECOND** or **SUBSEQUENT** preliminary amendment.
17. ☐ A substitute specification.
18. ☒ A change of power of attorney and/or address letter.
19. ☐ A computer-readable form of the sequence listing in accordance with PCT Rule 13ter.2 and 35 U.S.C. 1.821 - 1.825.
20. ☐ A second copy of the published international application under 35 U.S.C. 154(d)(4).
21. ☐ A second copy of the English language translation of the international application under 35 U.S.C. 154(d)(4).
22. ☒ Certificate of Mailing by Express Mail
23. ☒ Other items or information:

**Copy of Amendment under Article 34**

U.S. APPLICATION NO. (IF KNOWN, SEE 37 CFR 1.101) <b>10/089558</b>		INTERNATIONAL APPLICATION NO. <b>PCT/US00/26901</b>		ATTORNEY'S DOCKET NUMBER <b>TRM TR990031</b>	
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24. The following fees are submitted: <b>BASIC NATIONAL FEE ( 37 CFR 1.492 (a) (1) - (5) ) :</b> <input type="checkbox"/> Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO and International Search Report not prepared by the EPO or JPO ..... <b>\$1040.00</b> <input type="checkbox"/> International preliminary examination fee (37 CFR 1.482) not paid to USPTO but International Search Report prepared by the EPO or JPO ..... <b>\$890.00</b> <input type="checkbox"/> International preliminary examination fee (37 CFR 1.482) not paid to USPTO but international search fee (37 CFR 1.445(a)(2)) paid to USPTO ..... <b>\$740.00</b> <input checked="" type="checkbox"/> International preliminary examination fee (37 CFR 1.482) paid to USPTO but all claims did not satisfy provisions of PCT Article 33(1)-(4) ..... <b>\$710.00</b> <input type="checkbox"/> International preliminary examination fee (37 CFR 1.482) paid to USPTO and all claims satisfied provisions of PCT Article 33(1)-(4) ..... <b>\$100.00</b> <b>ENTER APPROPRIATE BASIC FEE AMOUNT =</b>				<b>CALCULATIONS PTO USE ONLY</b>  <div style="border: 1px solid black; height: 100px; width: 100%;"></div>	
Surcharge of <b>\$130.00</b> for furnishing the oath or declaration later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492 (e)).				<b>\$710.00</b>	
CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE		
Total claims	25 - 20 =	5	x \$18.00	<b>\$90.00</b>	
Independent claims	2 - 3 =	0	x \$84.00	<b>\$0.00</b>	
Multiple Dependent Claims (check if applicable). <input type="checkbox"/>				<b>\$0.00</b>	
<b>TOTAL OF ABOVE CALCULATIONS =</b>				<b>\$800.00</b>	
<input type="checkbox"/> Applicant claims small entity status. See 37 CFR 1.27). The fees indicated above are reduced by 1/2.				<b>\$0.00</b>	
<b>SUBTOTAL =</b>				<b>\$800.00</b>	
Processing fee of <b>\$130.00</b> for furnishing the English translation later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492 (f)).				<b>\$0.00</b>	
<b>TOTAL NATIONAL FEE =</b>				<b>\$800.00</b>	
Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31) (check if applicable). <input type="checkbox"/>				<b>\$0.00</b>	
<b>TOTAL FEES ENCLOSED =</b>				<b>\$800.00</b>	
				Amount to be refunded	\$
				charged	\$

a. ☒ A check in the amount of **\$800.00** to cover the above fees is enclosed.

b. ☐ Please charge my Deposit Account No. \_\_\_\_\_ in the amount of \_\_\_\_\_ to cover the above fees. A duplicate copy of this sheet is enclosed.

c. ☒ The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. **50-2121** A duplicate copy of this sheet is enclosed.

d. ☐ Fees are to be charged to a credit card. **WARNING:** Information on this form may become public. **Credit card information should not be included on this form.** Provide credit card information and authorization on PTO-2038.

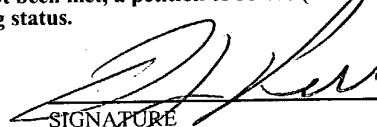
**NOTE:** Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed and granted to restore the application to pending status.

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 REGISTRATION NUMBER

**April 1, 2002**  
 DATE

1     **METHOD AND APPARATUS FOR MOLDING PLASTIC MATERIALS**  
2     **WITH A METALLIC APPEARANCE**

3     The present invention relates to a method and apparatus for molding plastic  
4 materials with a metallic appearance and, more particularly, to an injection mold having  
5 interchangeable gate inserts that supply molten thermoplastic material into a mold cavity.

6     As used in this specification, a colorant is any material that can impart color to  
7 the medium in which it is used. The colorant may be insoluble or soluble in the  
8 medium. Generally, colorants may be divided into two broad categories; pigments  
9 and dyes. As used in this specification, a pigment may be organic or inorganic,  
10 natural or synthetic, and is generally insoluble in the medium in which it is used,  
11 while a dye is generally soluble in the medium in which it is used.

12     As used in this specification, a subcategory inclusive of pigments are pigments  
13 used to modify the optical characteristics of the medium in which they are used, such  
14 as light reflectivity, light refractivity, light absorbance, or light transmittance. A  
15 subcategory of pigments used to modify the optical characteristics of the medium in  
16 which they are used are light-reflective pigments. Light-reflective pigments include,  
17 but are not limited to, metallic pigments (also known as metallic-flake pigments) and  
18 glitter (also known as flitter or spangles). A metallic pigment is a particle or flake,  
19 generally of metal or alloy, used to modify the optical characteristics of the medium,  
20 such as reflectivity, or to achieve a metallic appearance. The metals most commonly  
21 used include, but are not limited to, gold, silver, aluminum, copper, bronze, and zinc.  
22 Materials other than metals which may be used to achieve a metallic appearance  
23 include minerals (e.g. mica) or glass. These materials generally are all used in flake  
24 form.

25     Typically, products molded from plastic materials include, but are not limited  
26 to, automotive body panels, fascias and claddings. In the automotive industry, a  
27 preferred method of forming such products is injection molding of a plastic material,  
28 preferably that of a thermoplastic composition. Injection molding is preferred over  
29 other plastic forming techniques given its combination of high volume production  
30 with relatively low cost materials.

31     After molding, or post-molding, often a metallic appearance is applied to such  
32 automotive products in the form of a coating. Typically, this metallic appearance is

1 achieved via a painting operation via the use of a metallic paint. A metallic paint is a  
2 paint which incorporates the use of a metallic pigment defined above.

3 Recently, there has been a desire to eliminate the post-molding application of  
4 a metallic appearance, such as via metallic paint, to such automotive products. There  
5 has been a desire to incorporate the metallic appearance for such automotive products  
6 during the forming, or molding, of the product itself. The incorporation of the  
7 metallic appearance for such automotive products during the forming of the product is  
8 desired to reduce cost, and the emission of potentially harmful volatile organic  
9 compounds (VOCs) into the atmosphere common to the painting process.

More particularly, there is a desire to incorporate the metallic appearance for such automotive products into the composition used for forming, or molding, the automotive product itself. There has also been a desire that the composition of the automotive product comprise a plastic material, preferably a thermoplastic material. Furthermore, there also has been a desire to form the above preferred thermoplastic material by a molding process, and, more particularly, an injection molding process.

16 More recently, attempts have been made to incorporate a metallic appearance  
17 into automotive products via thermoplastic injection molding. It has been found,  
18 through experimentation, that an acceptable level of quality of the molded automotive  
19 product can be achieved with an injection molding process and thermoplastic  
20 compositional alterations. Such is demonstrated by the 1999 Jeep Grand Cherokee  
21 Laredo front fascia, rear fascia and claddings, manufactured using an injection  
22 molding process with Solvay Engineered Polymers' Sequel 1440 grade of  
23 thermoplastic olefin (TPO) composition.

24 However, it has also been found that injection molding process and  
25 compositional-alterations required to produce an acceptable level of quality may vary  
26 significantly with each particular thermoplastic composition employed. More  
27 specifically, it has been found that, when different metallic pigments are used to  
28 achieve various metallic appearances and/or colors, the injection molding process and  
29 compositional alterations required to produce an acceptable level of quality between  
30 compositions may vary significantly. It has also been found that, in some cases, that  
31 even altering the injection molding process and thermoplastic composition, within  
32 acceptable limits, still may not produce an acceptable level of quality. Typically,

1 such products did not produce an acceptable level of quality due to the presence of a  
2 differing metallic appearance on different locations on the surface of the product.  
3 This differing metallic appearance most noticeably appears in areas of the surface  
4 occupied by weld lines versus those areas of the surface without weld lines. Weld  
5 lines (also known as knit lines, flow lines, or weld marks) in a molded plastic product  
6 mark the meeting of different plastic flow fronts within a mold. According to  
7 Whittington's Dictionary of Plastics, 3<sup>rd</sup> Edition, the flow fronts may have cooled and  
8 skinned over before meeting, or had too little time in the molten state for  
9 interdiffusion of molecular segments across the interface.

10 As a result of the above difficulties, apparatus alterations, in addition to  
11 injection molding process and thermoplastic composition alterations, were the subject  
12 of experimentation. Specifically, apparatus alterations focused on alterations to the  
13 injection mold used for the injection molding process. More specifically, injection  
14 mold alterations focused on gate design, such as size, configuration, and location. In  
15 injection molding, the gate is the channel through which molten plastic flows from the  
16 runner into the mold cavity.

17 From experimentation, it was found that altering the injection mold gate  
18 design, in addition to altering the injection molding process and thermoplastic  
19 composition, produced an acceptable level of quality. In other words, gate design had  
20 an effect on controlling different plastic flow fronts and weld line formation within  
21 the mold cavity such that the metallic appearance across the surface of the part could  
22 be made more uniform as to produce an acceptable level of quality. However, having  
23 different injection mold gate designs for each thermoplastic composition could only  
24 be achieved by means of significant injection mold alterations requiring substantial  
25 time not suitable for high volume production. Alternatively, the requirement of  
26 injection mold alterations could be eliminated with the fabrication of a different  
27 injection mold for each thermoplastic composition. However, the cost of different  
28 injection molds for each thermoplastic composition is prohibitive given the size of  
29 automotive products. Consequently, what was needed was an injection molding  
30 process, and more particularly, an injection mold apparatus in the form of an injection  
31 mold, which would facilitate quick, inexpensive gate design alterations to facilitate

1 high volume, low cost production of thermoplastic injection molded automotive  
2 products with a metallic appearance.

3 An apparatus for molding plastic materials is provided comprising a mold having  
4 a first mold section (12) and a second mold section (14) with a mold cavity (16) disposed  
5 in between. A first gate design is provided by at least one first gate design mold member  
6 (40), and a second gate design is provided by at least one second gate design mold  
7 member. Preferably, date design mold member (40) is defined by two interchangeable  
8 members 41 and 42. Also preferably, the first and second gate design mold members are  
9 removably attachable to, and interchangeable on, at least one of the first or the second  
10 mold sections (12, 14) to change from the first gate design to the second gate design. A  
11 method for molding plastic materials is also provided comprising providing a mold  
12 having a first mold section (12) and a second mold section (14) with a mold cavity (16)  
13 disposed in between; providing a first gate design; forming a product in the mold cavity  
14 (16) by providing a first plastic material through the first gate design; separating the first  
15 mold section (12) and the second mold section (14); removing the product from the mold  
16 cavity (16); changing from the first gate design to a second gate design; forming a  
17 product in the mold cavity (16) by providing a second plastic material through the second  
18 gate design. In the above manner, the formation of weld lines on the product may be  
19 controlled.

20 Other advantages of the present invention will be readily appreciated, as the same  
21 becomes better understood by reference to the following detailed description when  
22 considered in connection with the accompanying drawings wherein:

23 FIG.1 is a perspective view of a mold apparatus and feed system with the mold  
24 and feed system partially cut away;

25 FIG.2 is a top plan view of the molded article also showing the runner system and  
26 the gate; and

27 FIG.3 is a side sectional view of a similar embodiment of the invention showing  
28 a mold and feed system taken along a vertical plane through the runner and gate.

29 Referring to the Figures, wherein like numerals indicate like or corresponding  
30 parts throughout the several views, an injection molding apparatus is generally shown at  
31 10. The injection molding apparatus 10 includes first and second mold sections 12, 14  
32 defining a mold cavity 16. Also, a material feed system 18 includes an elongated gate



1 Preferably, the runner portion 22 includes at least one, and preferably two, cold slugs 36  
2 for trapping and storing any unmelted pieces of material passed through the runners.

3 The next element downstream of the runner portions is the gate portion 20. As  
4 stated, the gate portion 20 extends along a significant portion of the edge of the mold  
5 cavity 16. Thus, the gate portion 20 is sometimes referred to as an edge gate. As shown  
6 in FIG. 3, an orifice 38 is defined at the gate portion 20. In other words, the gate portion  
7 20 is smaller or narrower in dimension than the first section 22a of the runner portion 22.  
8 The runner portion 22 tapers in dimension down to the gate portion 20. Experimentation  
9 with the Solvay Engineered Products' Engineered Polymers' Sequel 1440 grade of  
10 thermoplastic olefin (TPO) composition has an orifice 38 thickness between mold  
11 sections 12, 14 in the range of 0.010" to the nominal thickness of the product, more  
12 particularly from 0.010" to 0.060", and even more particularly preferred in the range  
13 of 0.030" to 0.050", and in any 0.001" increment therebetween. The length of the  
14 orifice 38 in relation to the thicknesses above preferably is in the range of 0.040" to  
15 the nominal length of the product, more particularly from 0.250" to 10.0", and even  
16 more particularly from 0.50" to 1.0", and in any 0.001" increment therebetween.

17 In operation, the mold sections 12, 14 close to define the mold cavity 16 and the  
18 feed system 18. Then, the operator causes a first molten plastic material, preferably a  
19 first thermoplastic composition, to flow into the feed system 18 into drop 28. The  
20 material travels through the drop 28 to the runner portion 22 and the runners conduct the  
21 material into the gate portion 20. The material from the runner portion 22 is initially  
22 impeded from flowing into the mold cavity 16 by the narrower dimension of the gate and  
23 begins merging and mixing upstream of the gate portion 20, and then continues to merge  
24 and mix in the gate portion 20 as it moves into the mold cavity 16 once the feed system  
25 along the gate is filled with material. Any unmelted pieces of material or other  
26 impurities in unmelted particle form will be trapped and retained in the cold slugs 36.  
27 Once the mold cavity 16 fills, the material can cool and harden. Then the mold sections  
28 12, 14 can be separated and the molded article removed.

29 After the injection molding of product with the first plastic material is complete,  
30 the mold sections 12, 14 are separated and interchangeable members 41, 42 are removed  
31 from the recesses 50, 52 thereof. Thereupon, new interchangeable members, which  
32 correspond to an acceptable gate design for a second plastic material, are inserted into the



1 recesses 50,52 and fixed to mold sections 12, 14 in a similar manner to interchangeable  
2 members 41,42. It should be understood that each plastic material may have its own  
3 interchangeable members to define its own gate design 40 as required to manufacture  
4 acceptable products. Once the new interchangeable members 41,42 have been fixed  
5 within the recesses 50, 52 of mold sections 12,14, the apparatus 10 is now ready for  
6 processing the second plastic material.

7         The invention has been described in an illustrative manner, and it is to be  
8 understood that the terminology which has been used is intended to be in the nature of  
9 words of description rather than of limitation.

10         Obviously, many modifications and variations of the present invention are  
11 possible in light of the above teachings. Therefore, it is to be understood that within the  
12 scope of the appended claims the invention may be practiced otherwise than as  
13 specifically described. Moreover, the reference numerals are merely for convenience and  
14 are not intended to be in any way limiting.

15

We claim:

1. An apparatus for molding plastic articles having pigments used to modify light reflectivity comprising:
  - a mold having a first mold section (12) and a second mold section (14) with a mold cavity (16) disposed between the first and the second mold sections (12, 14);
  - a first gate design for providing a first plastic material to the mold cavity (16) provided by at least one first gate design mold member (40);
  - a second gate design for providing a second plastic material to the mold cavity (16) provided by at least one second gate design mold member;
  - the first and second gate design mold members removably attachable to at least one of the first or the second mold sections (12, 14);
  - the first and second gate design mold members interchangeable on at least one of the first or the second mold sections (12, 14) to change from the first gate design to the second gate design.
2. The apparatus for molding plastic materials of claim 1 wherein the mold comprises an injection mold.
3. The apparatus for molding plastic materials of claim 1 wherein the first gate design comprises an edge gate.
4. The apparatus for molding plastic materials of claim 1 wherein the second gate design comprises an edge gate.
5. The apparatus for molding plastic materials of claim 1 wherein at least one of said first or second mold sections contains a recess and said first or second gate design mold member is insertable in said recess.
6. The apparatus for molding plastic materials of claim 1 wherein the first gate design mold member is removably attachable to the first or the second mold section by threaded fasteners.

7. The apparatus for molding plastic materials of claim 1 wherein the second gate design mold member is removably attachable to the first or the second mold section by threaded fasteners.

8. The apparatus for molding plastic materials of claim 1 wherein the first gate design is provided by at least two interchangeable mold members (41, 42).

9. The apparatus for molding plastic materials of claim 1 wherein the second gate design is provided by at least two interchangeable mold members.

10. The apparatus for molding plastic materials of claim 1 wherein the first plastic material comprises a thermoplastic polymer.

11. The apparatus for molding plastic materials of claim 10 wherein the first plastic material further comprises a pigment.

12. The apparatus for molding plastic materials of claim 11 wherein the pigment further comprises a light-reflective pigment.

13. The apparatus for molding plastic materials of claim 11 wherein the pigment further comprises a metallic pigment.

14. The apparatus for molding plastic materials of claim 1 wherein the second plastic material comprises a thermoplastic polymer.

15. The apparatus for molding plastic materials of claim 14 wherein the second plastic material further comprises a pigment.

16. The apparatus for molding plastic materials of claim 15 wherein the pigment further comprises a light-reflective pigment.

17. The apparatus for molding plastic materials of claim 15 wherein the pigment further comprises a metallic pigment.

18. A method for molding plastic articles having pigments used to modify light reflectivity, the method comprising:

providing a mold having a first mold section (12) and a second mold section (14) with a mold cavity (16) disposed between the first and the second mold sections (12, 14);

providing a first gate design;

forming a product in the mold cavity (16) by providing a first plastic material through the first gate design;

separating the first mold section (12) and the second mold section (14);

removing the product from the mold cavity (16);

changing from the first gate design to a second gate design;

forming a product in the mold cavity (16) by providing a second plastic material through the second gate design.

19. The method for molding plastic materials of claim 18 wherein the mold comprises an injection mold.

20. The method for molding plastic materials of claim 18 wherein the first gate design comprises an edge gate.

21. The method for molding plastic materials of claim 18 wherein the second gate design comprises an edge gate.

22. The method for molding plastic materials of claim 22 wherein:

the first gate design is provided by at least two interchangeable mold members;

and

the second gate design is provided by at least two interchangeable mold members.

23. The method for molding plastic materials of claim 22 wherein at least one of said first or second mold section contains a recess and said first or second gate design is insertable in said recess.

24. The method for molding plastic materials of claim 18 wherein the first gate design mold member is removably attachable to the first or the second mold section by threaded fasteners.

25. The method for molding plastic materials of claim 18 wherein the second gate design mold member is removably attachable to the first or the second mold section by threaded fasteners.

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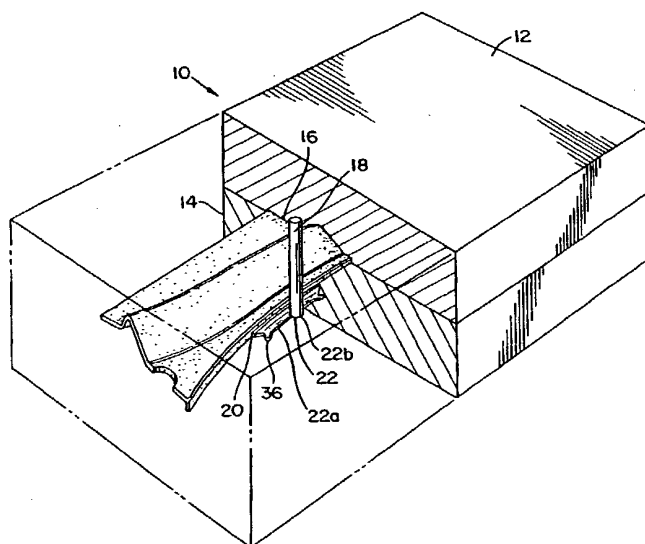
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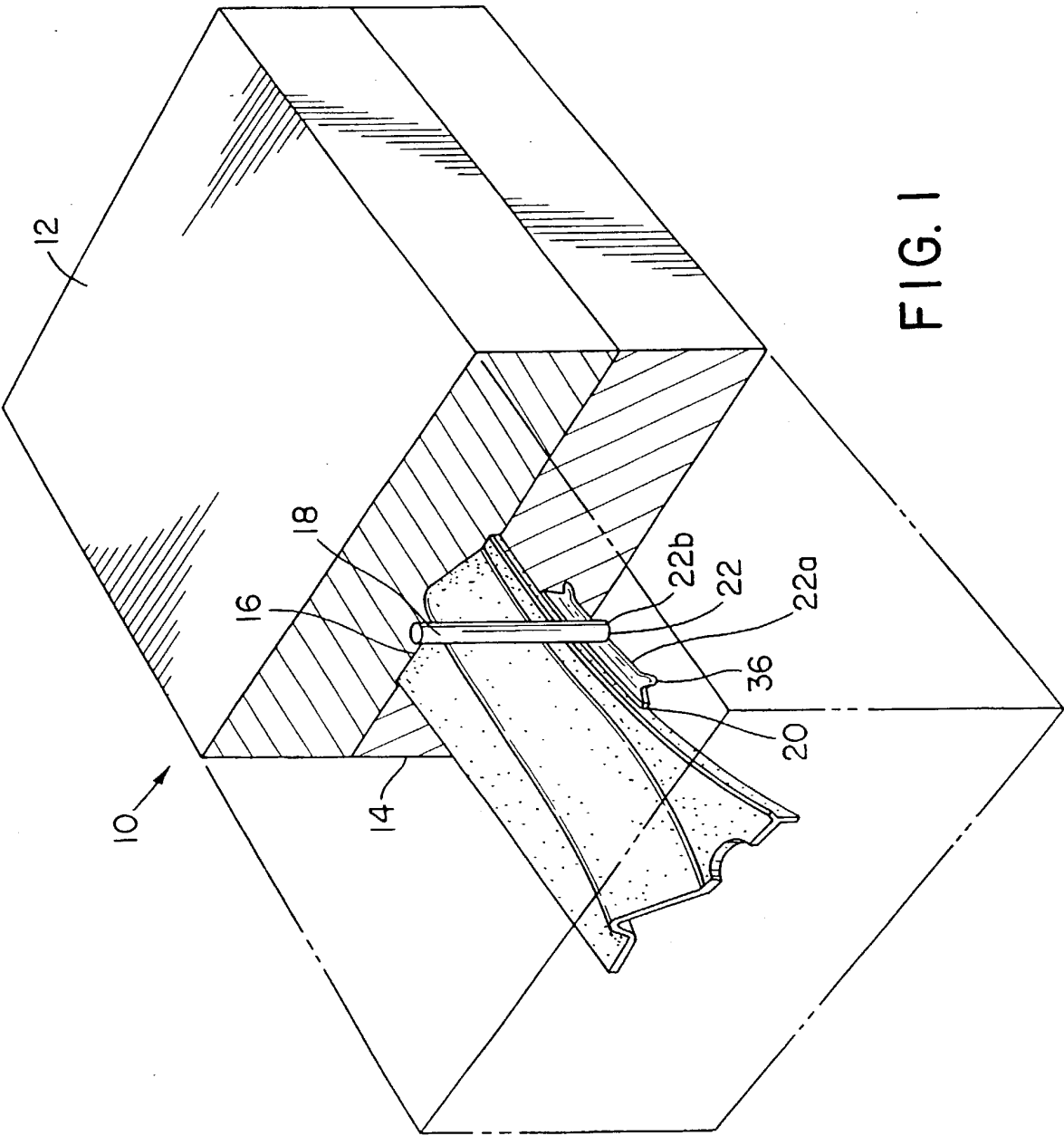
For two-letter codes and other abbreviations, refer to the "Guid-  
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ning of each regular issue of the PCT Gazette.

(54) Title: METHOD AND APPARATUS FOR MOLDING PLASTIC MATERIALS WITH A METALLIC APPEARANCE



(57) Abstract: An apparatus and method for molding plastic materials is provided comprising a mold having a first mold section (12) and a second mold section (14) with a mold cavity (16) disposed in between. A first gate design is provided by at least one first gate design mold member (40), and a second gate design is provided by at least one second gate design mold member. The first and second gate design mold members are removably attachable to, and interchangeable on, at least one of the first or the second mold sections (12, 14) to change from the first gate design to the second gate design.

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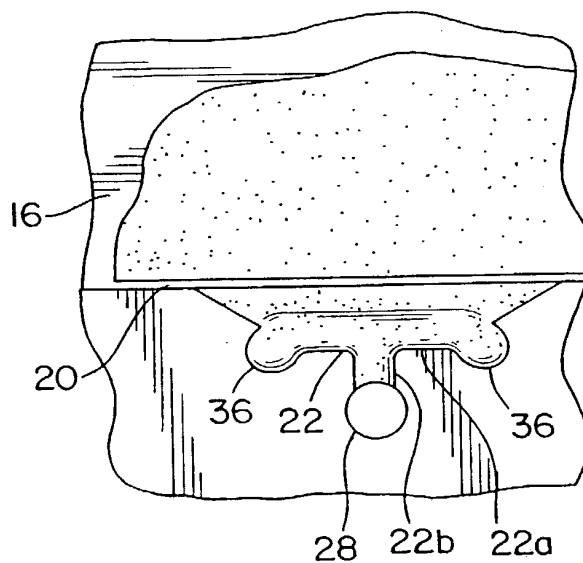


FIG. 2

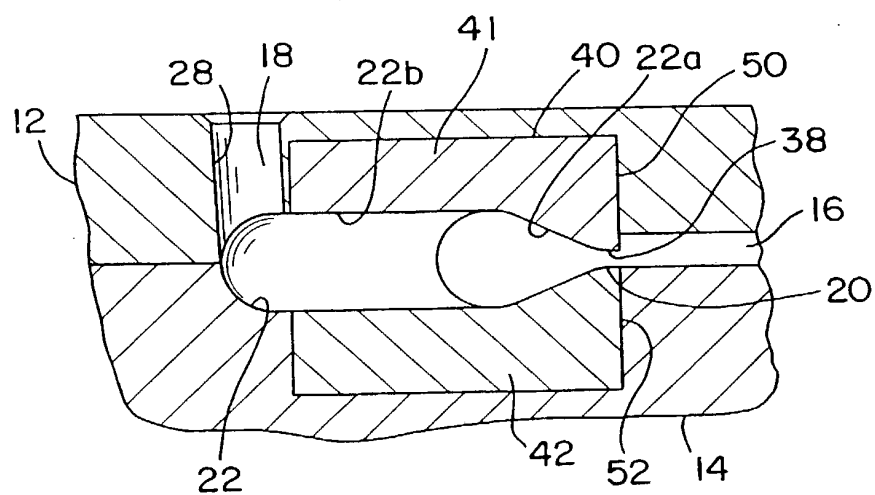


FIG. 3



Docket No.  
TRM TR990031

## Declaration and Power of Attorney For Patent Application

### English Language Declaration

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name,

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled

**METHOD AND APPARATUS FOR MOLDING PLASTIC MATERIALS WITH  
A METALLIC APPEARANCE**

the specification of which

(check one)

☐ is attached hereto.

☒ was filed on I.A.: September 29, 2000 as United States Application No. or PCT International  
Application Number 10/089,558  
and was amended on \_\_\_\_\_

(if applicable)

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose to the United States Patent and Trademark Office all information known to me to be material to patentability as defined in Title 37, Code of Federal Regulations, Section 1.56.

I hereby claim foreign priority benefits under Title 35, United States Code, Section 119(a)-(d) or Section 365(b) of any foreign application(s) for patent or inventor's certificate, or Section 365(a) of any PCT International application which designated at least one country other than the United States, listed below and have also identified below, by checking the box, any foreign application for patent or inventor's certificate or PCT International application having a filing date before that of the application on which priority is claimed.

Prior Foreign Application(s)

Priority Not Claimed

(Number)

(Country)

(Day/Month/Year Filed)

☐

(Number)

(Country)

(Day/Month/Year Filed)

☐

(Number)

(Country)

(Day/Month/Year Filed)

☐



POWER OF ATTORNEY: As a named inventor, I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the Patent and Trademark Office connected therewith. (list name and registration number)

Steven J. Grossman  
Donald J. Perreault  
Edmund P. Pfleger  
Scott R. Faber

Reg. No. 35,001

Reg. No. 40,126

Reg. No. 41,252

Reg. No. 48,380

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Direct Telephone Calls to: (name and telephone number)  
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Full name of sole or first inventor <u>Paul S. LAEATA</u>	<u>Paul S. Laeata</u>	<u>10/17/02</u>
Sole or first inventor's signature		Date
Residence <u>48055 Mallard Road, Chesterfield, Michigan 48047</u>	<u>ME</u>	
Citizenship <u>US</u>		
Post Office Address <u>same as residence address</u>		

Full name of second inventor, if any <u>Jack W. HISE</u>	
Second inventor's signature	Date
Residence	
Citizenship <u>US</u>	
Post Office Address <u>P.O. Box 312, Evart, Michigan 49631</u>	

Docket No.  
TRM TR990031

# Declaration and Power of Attorney For Patent Application

## English Language Declaration

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name,

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled

**METHOD AND APPARATUS FOR MOLDING PLASTIC MATERIALS WITH A METALLIC APPEARANCE**

the specification of which

(check one)

☐ is attached hereto.

☒ was filed on I.A.: September 29, 2000 as United States Application No. or PCT International Application Number 10/089,558 and was amended on \_\_\_\_\_

(if applicable)

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

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Prior Foreign Application(s)

Priority Not Claimed

(Number)

(Country)

(Day/Month/Year Filed)

☐

(Number)

(Country)

(Day/Month/Year Filed)

☐

(Number)

(Country)

(Day/Month/Year Filed)

☐

I hereby claim the benefit under 35 U.S.C. Section 119(e) of any United States provisional application(s) listed below:

60/157,147

30 September 1999

(Application Serial No.)

(Filing Date)

(Application Serial No.)

(Filing Date)

(Application Serial No.)

(Filing Date)

I hereby claim the benefit under 35 U. S. C. Section 120 of any United States application(s), or Section 365(c) of any PCT International application designating the United States, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States or PCT International application in the manner provided by the first paragraph of 35 U.S.C. Section 112, I acknowledge the duty to disclose to the United States Patent and Trademark Office all information known to me to be material to patentability as defined in Title 37, C. F. R., Section 1.56 which became available between the filing date of the prior application and the national or PCT International filing date of this application:

PCT/US00/26901

29 September 2000

pending

(Application Serial No.)

(Filing Date)

(Status)  
(patented, pending, abandoned)

(Application Serial No.)

(Filing Date)

(Status)  
(patented, pending, abandoned)

(Application Serial No.)

(Filing Date)

(Status)  
(patented, pending, abandoned)

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

POWER OF ATTORNEY: As a named inventor, I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the Patent and Trademark Office connected therewith. (list name and registration number)

Steven J. Grossman  
Donald J. Perreault  
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Steven J. Grossman 603.668.6560 Fax: 603.668.2970

Full name of sole or first inventor <b>Paul S. LAFATA</b>	
Sole or first inventor's signature <i>ME</i>	Date
Residence <b>48055 Mallard Road, Chesterfield, Michigan 48047</b>	
Citizenship <b>US</b>	
Post Office Address <b>same as residence address</b>	

Full name of second inventor, if any <b>Jack W. HISE</b>	
Second inventor's signature <i>Jack W. Hise</i>	Date <b>10-17-02</b>
Residence <b>12326 90<sup>th</sup> AVE EVART, MI 49631</b>	
Citizenship <b>US</b>	
Post Office Address <b>P.O. Box 312, Evart, Michigan 49631</b>	

Rec'd PCT/PTO 08 OCT 2002

# 3

PATENT  
IN THE UNITED STATE PATENT AND TRADEMARK OFFICE

In re application of LAFATA et al

For Method and Apparatus for Molding Plastic Materials  
with a Metallic Appearance

Serial Number 10/089,558

Filing Date September 29, 2000 (effectively from PCT)

Examiner April 1, 2002

Attorney Docket TRM TR990031

POWER TO INSPECT AND MAKE COPIES

Honorable Commissioner of  
Patents and Trademarks  
Washington, DC 20231

Dear Sir:

The undersigned attorney hereby authorizes DIGIPAT, its representatives, Terry Kramer, Jackie Brown, Jon James, Victor Telleria, William Rhodes, Moe Johnson of 2001 Jefferson Davis Highway, Suite 1111, Arlington, Virginia 22202 to inspect and make copies of the file for the above-identified application.

Respectfully submitted,

Attorney Name Steven J. Grossman

Reg. No. 35,001

Attorney for Applicant